

304 .000 0424
A3286-3

Work Order ID 73194

Friday, August 26, 2011 7:16:12 AM



Page 1

Item ID: D4425-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 8/26/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/08/26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4425

A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FB062 AND DWG

DWG REV: A

FOLIO REV: N/A

DEBURR

CL 10/8/22

10

0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

CL 10/8/22

10

0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 73194

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Page 2

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Start Date: 8/26/2011 Start Qty: 10.00



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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>11/09/23</i>		<i>10</i>			
130 Packaging Packaging	Identify as per dwg & Stock Location: <i>uA</i> Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00				<i>11/9/23</i>			<i>107</i>
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						<i>11/9/27</i>	<i>mk 11-09-23</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:16:09 AM

Page 1

Work Order ID: 73194



Parent Item: D4425-1

Parent Item Name: Step Spacer

Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	256.0684	0.25	2531579			
304 RD Tube .500 x .049W													

Location	Loc Qty	Loc Code
MAT017	256.068426	
111814	2.23	
115010	154.368426	
117598	99.47	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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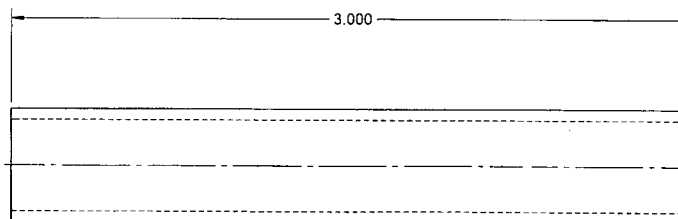
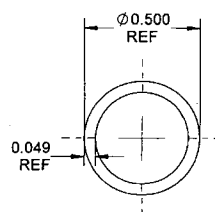
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73194

D4425-1 STEP SPACER



D4425-1 STEP SPACER

RELEASE
2011-07-28
WJL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING, $\varnothing 0.500 \times 0.049$ WALL
PER ASTM A213 OR ASME SA213 OR ASTM A269
REF M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

A		NEW ISSUE		DESCRIPTION		AJS	11.07.06
REV.						BY	DATE
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		AJS					
CHECKED				DRAWING NO.			REV. A
MFG. APPR.				D4425			SHEET 1 OF 1
APPROVED				TITLE			SCALE
DE APPR.				SPACER			NTS
DATE				11.07.06			

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W/O:		WORK ORDER CHANGES					
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